

**IN THE ABSTRACT**

Please substitute the following Abstract for the original Abstract:

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During welding of higher stiffness steels there is significant tendency towards hardening in the area of the weld seam, which introduces a loss in ductility and thus strongly reduces the durability and quality of the construction components. To reduce the loss in ductility of the weld seam and thereby to reduce the necessary apparatus complexity and to maintain or reduce the processing time, a process is proposed in which the welding and warming are carried out by a single laser beam with a substantial even output and focusing however with varying rates of advance.